

1/17

FIG. 1

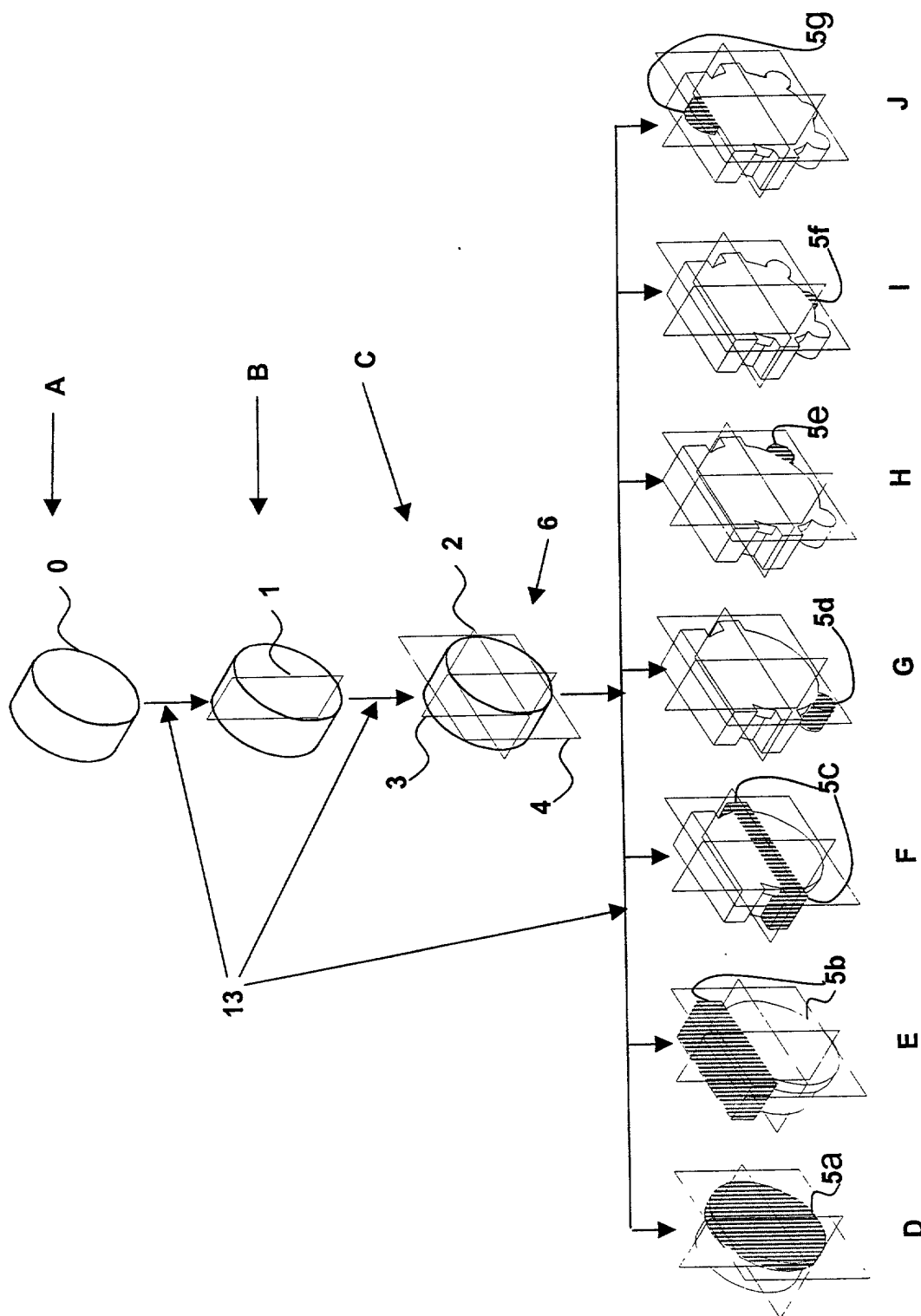


FIG. 1

2/17

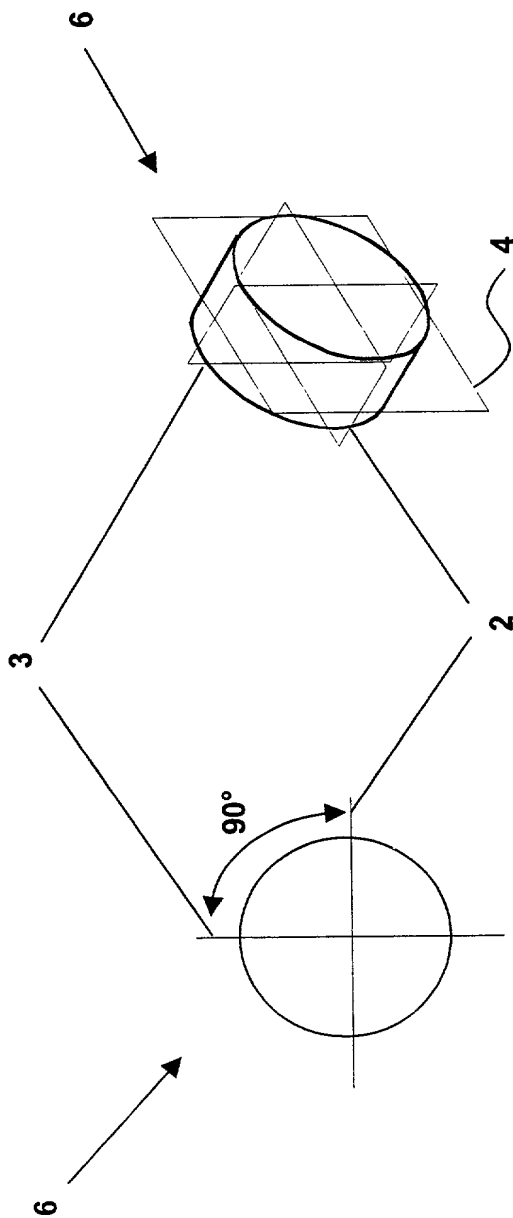


FIG. 2

FIG. 2

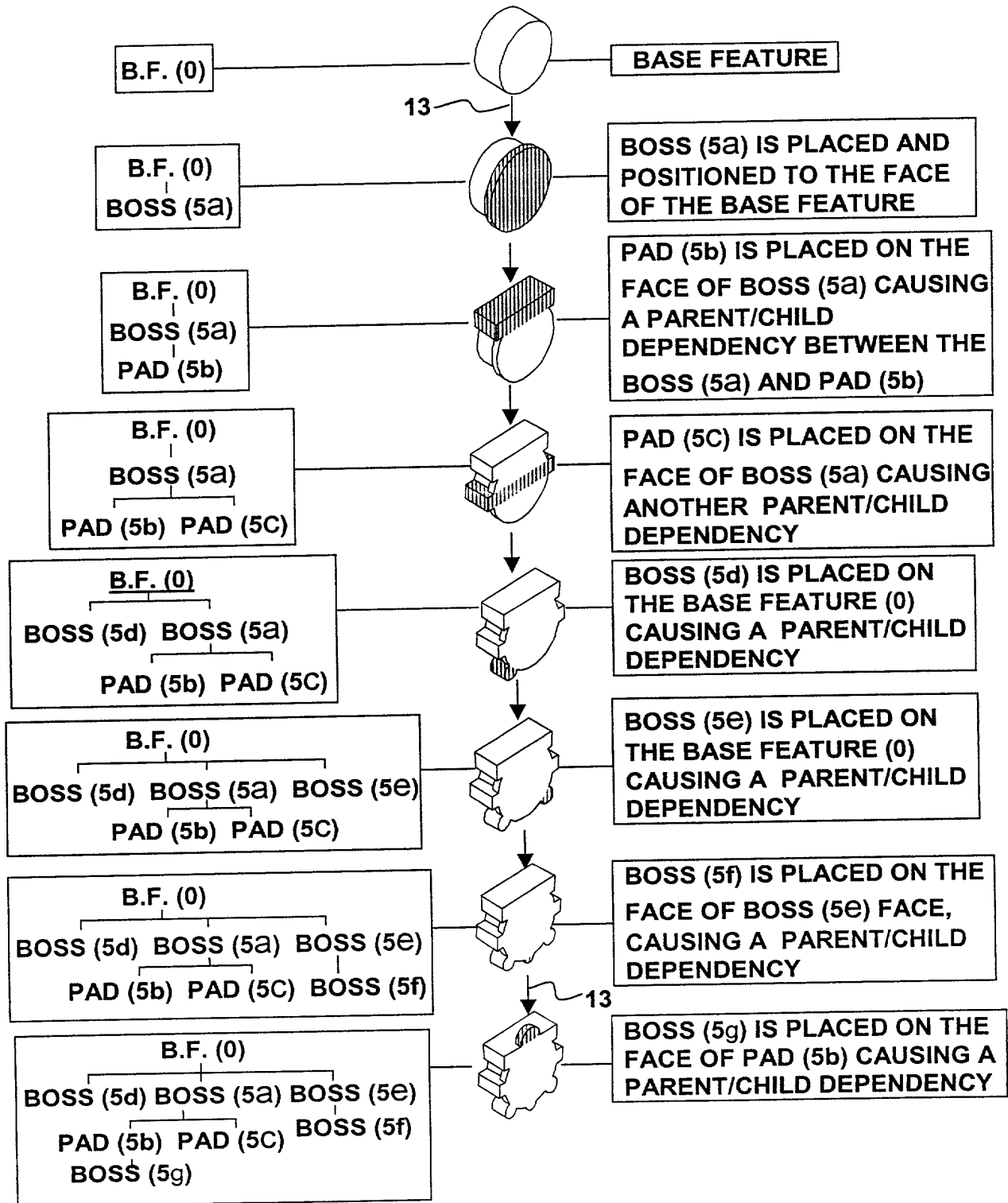
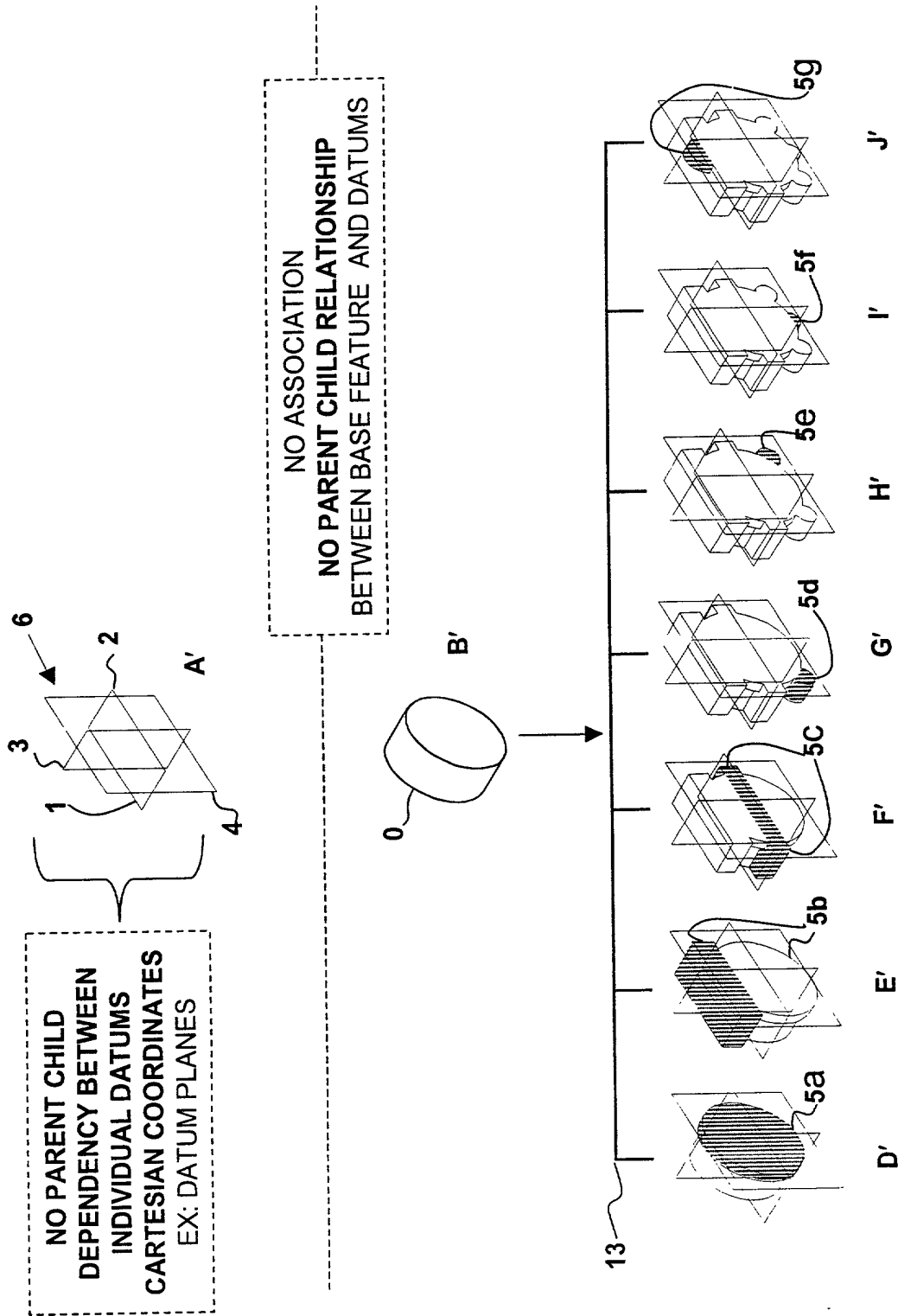
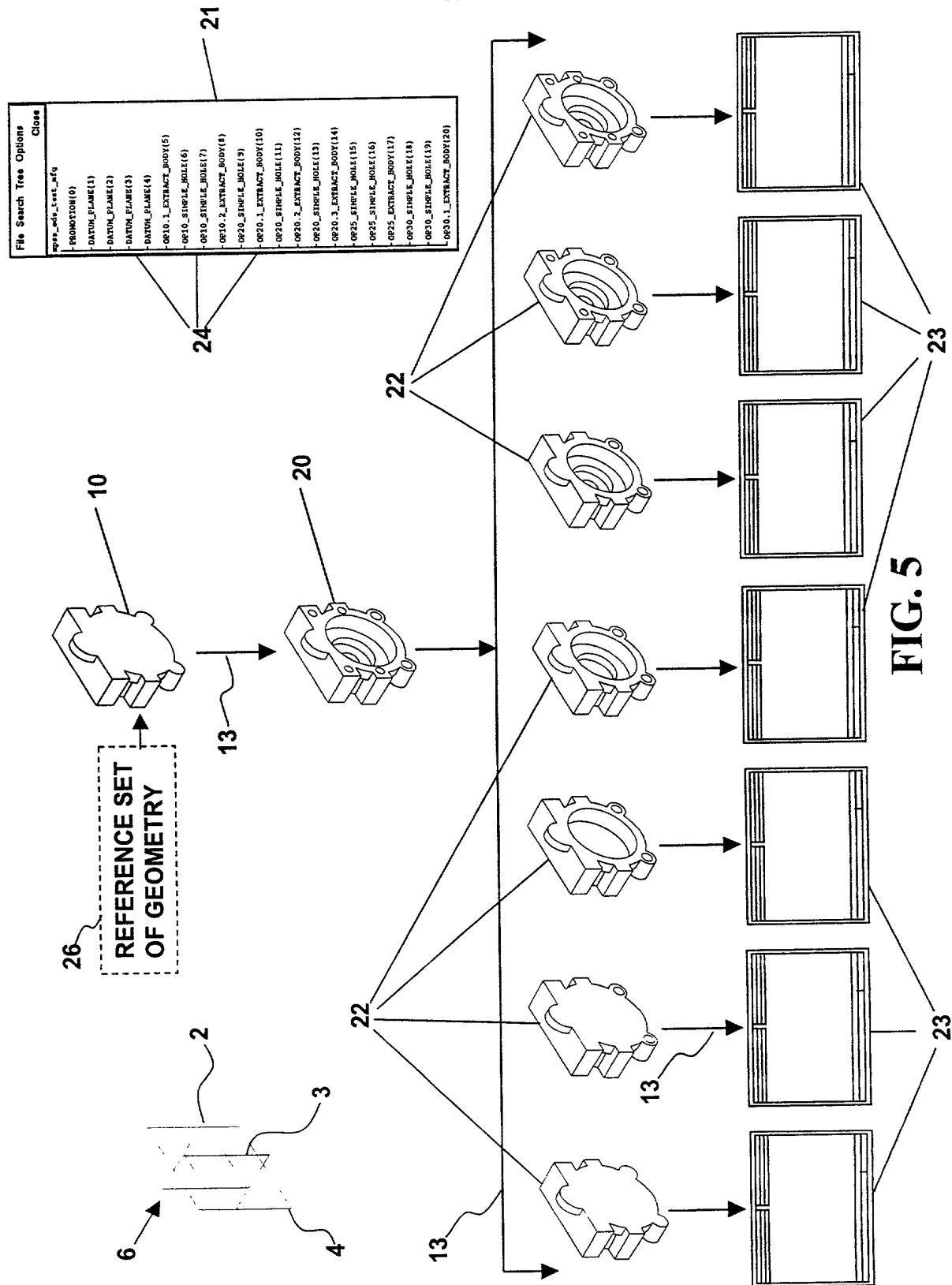


FIG. 3





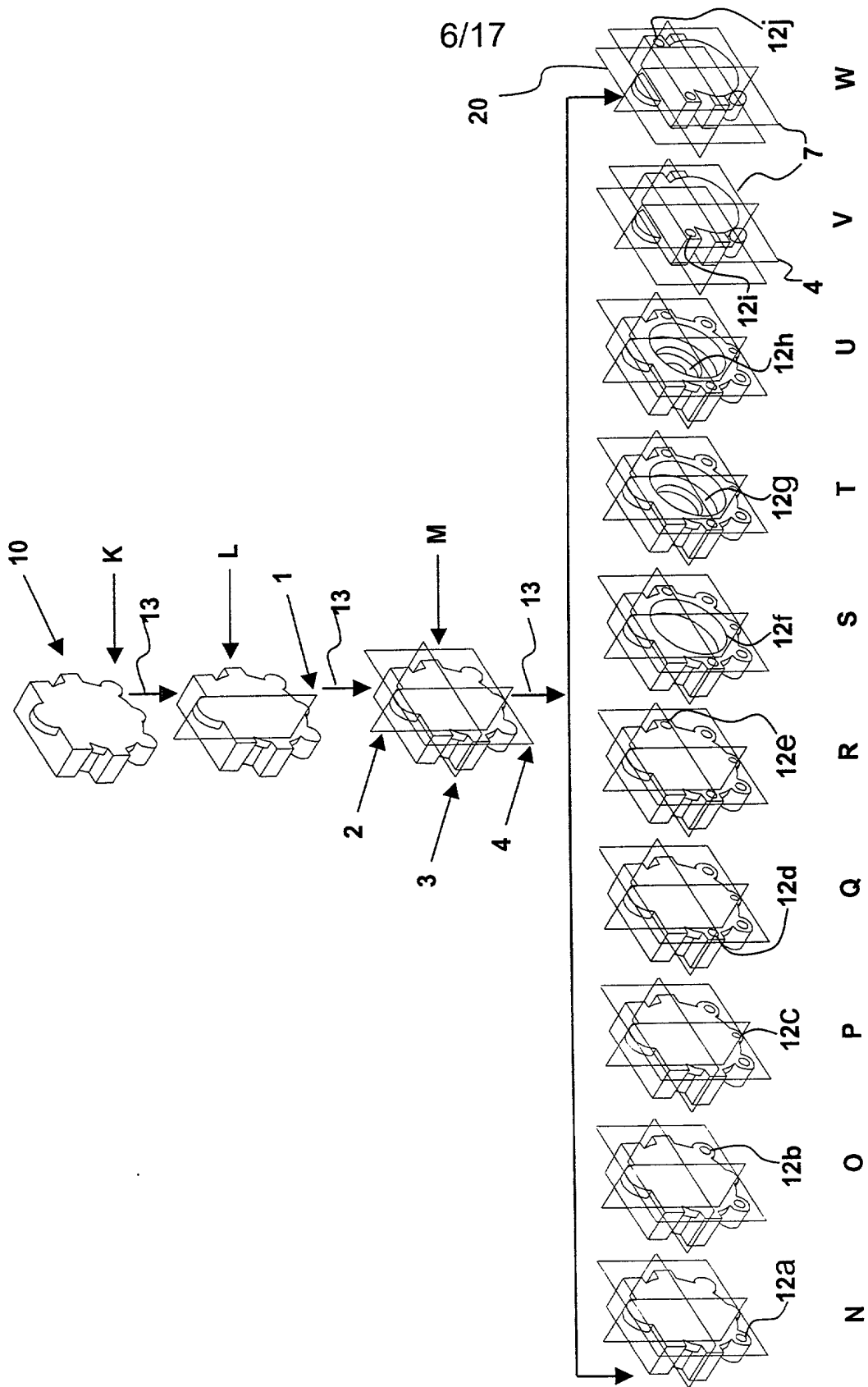


FIG. 6

7/17

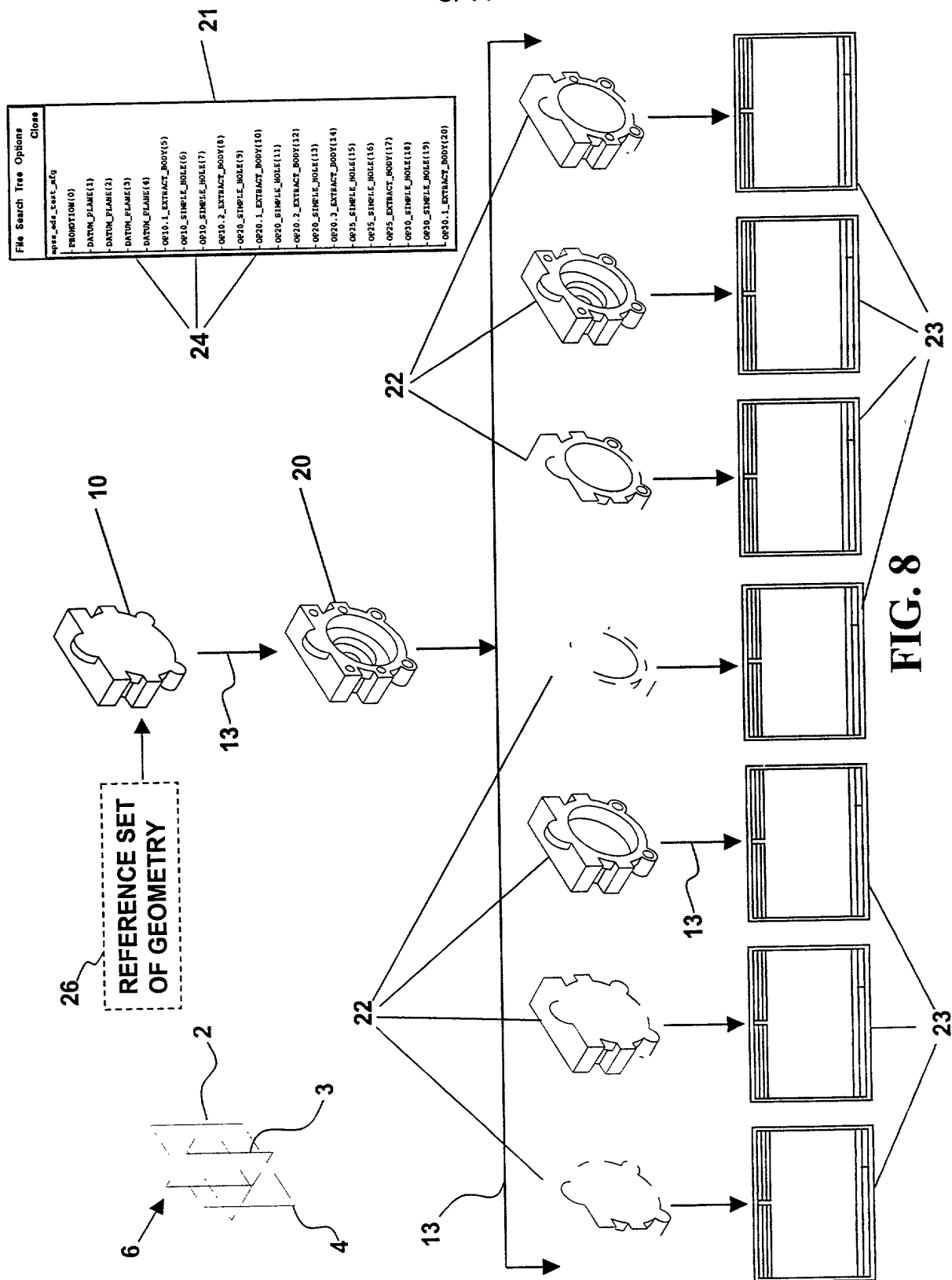
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23

[illegible]

FIG. 7

8/17



9/17

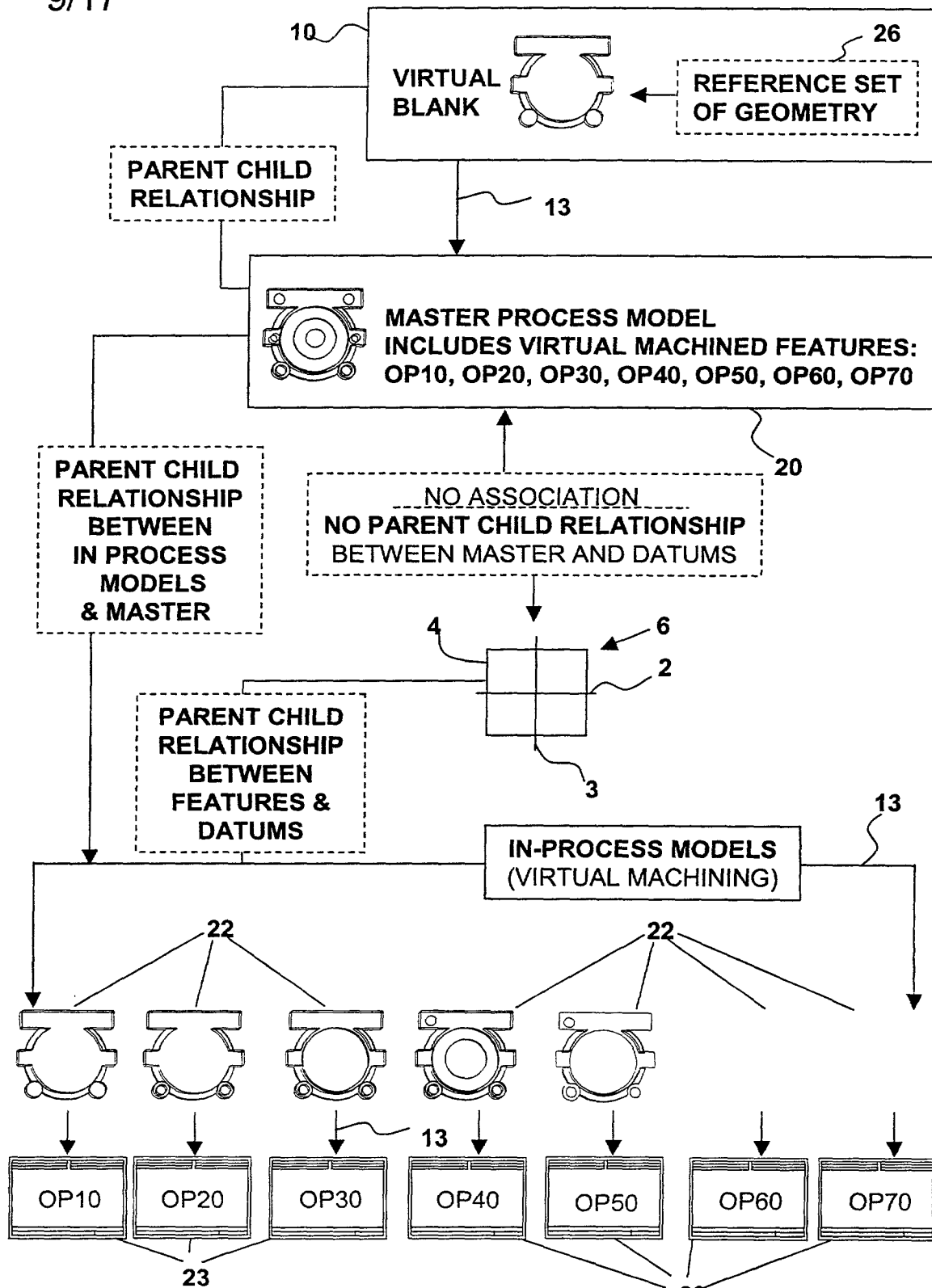


FIG. 9

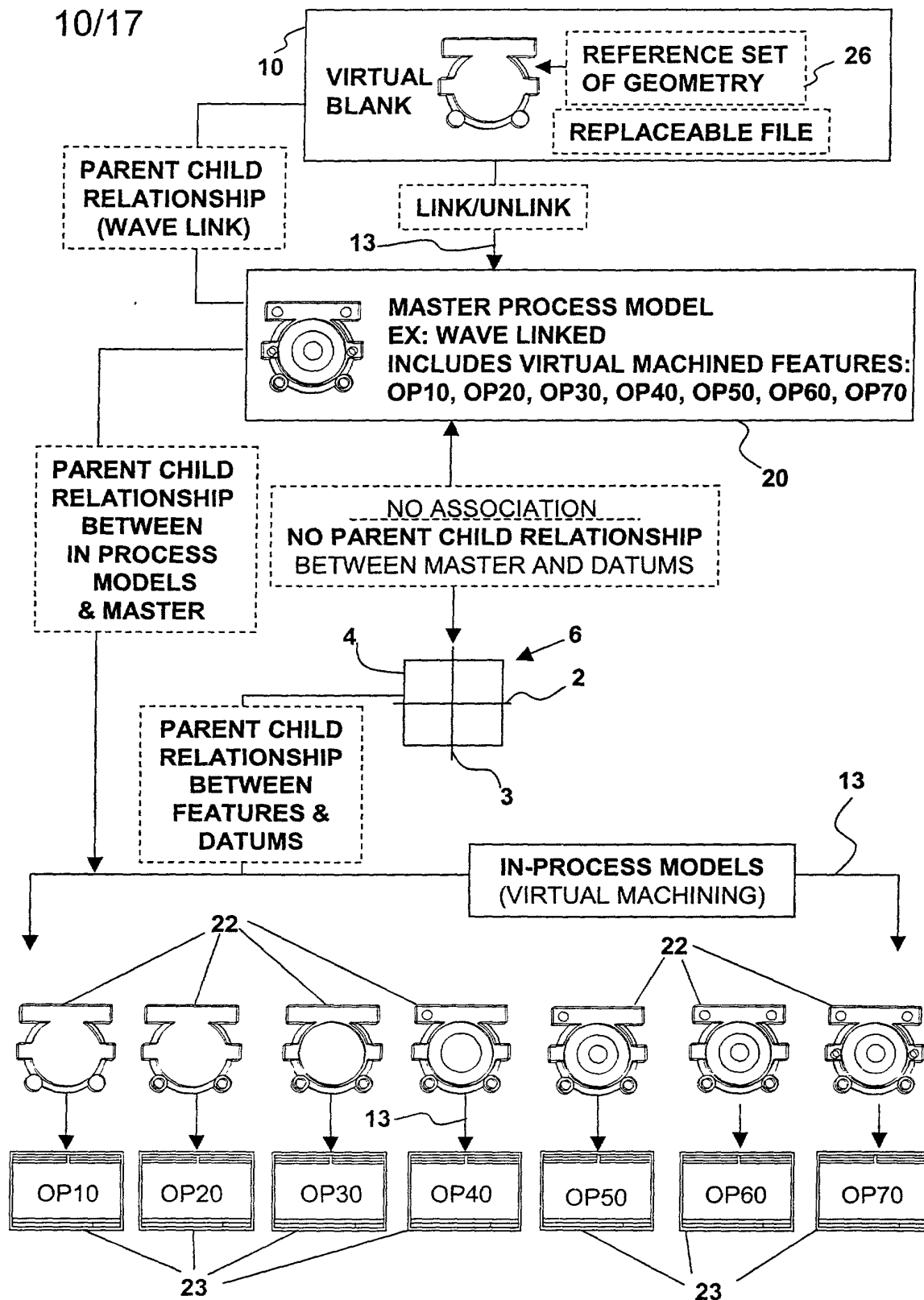


FIG. 10

11/17

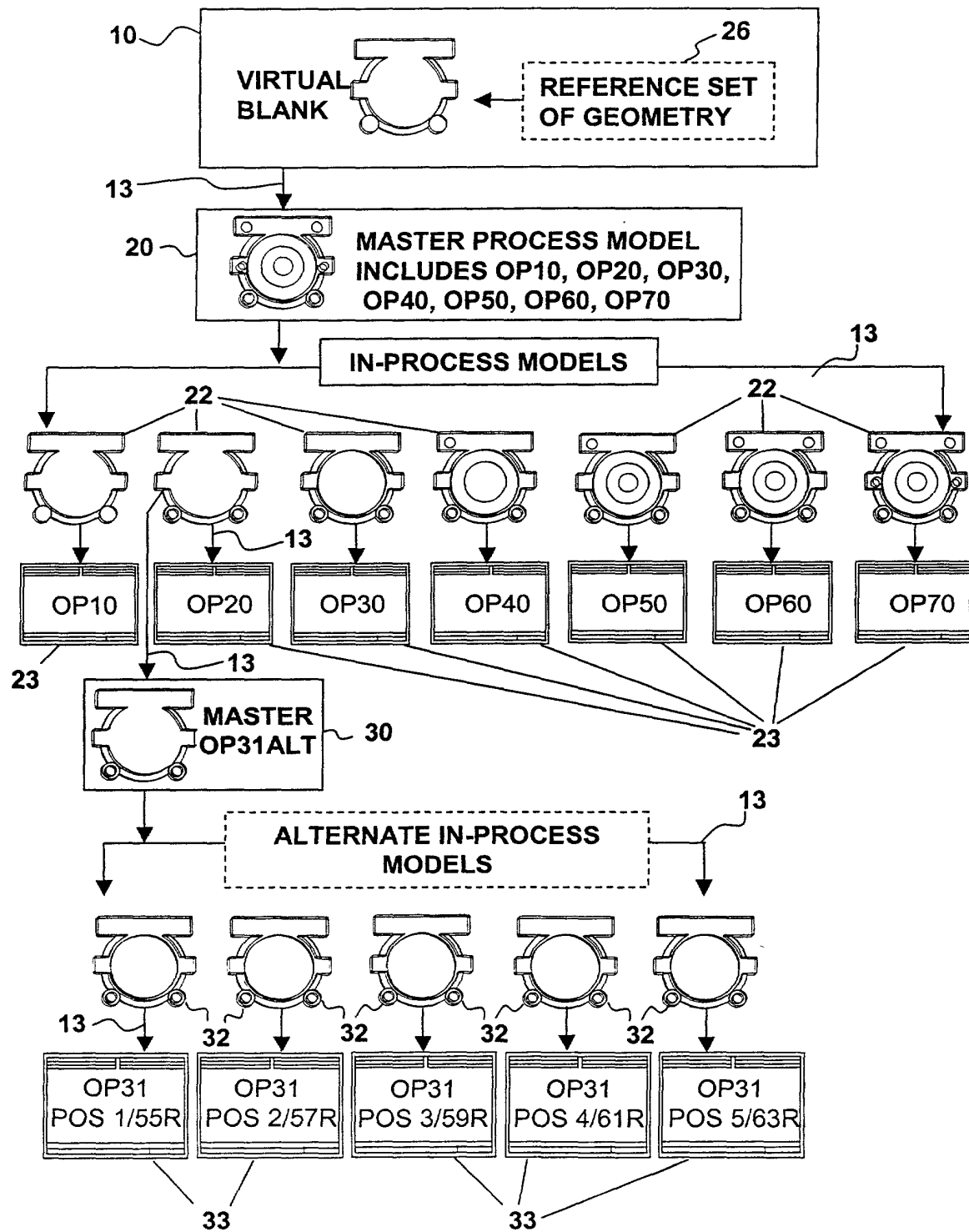


FIG. 11

FIG. 12

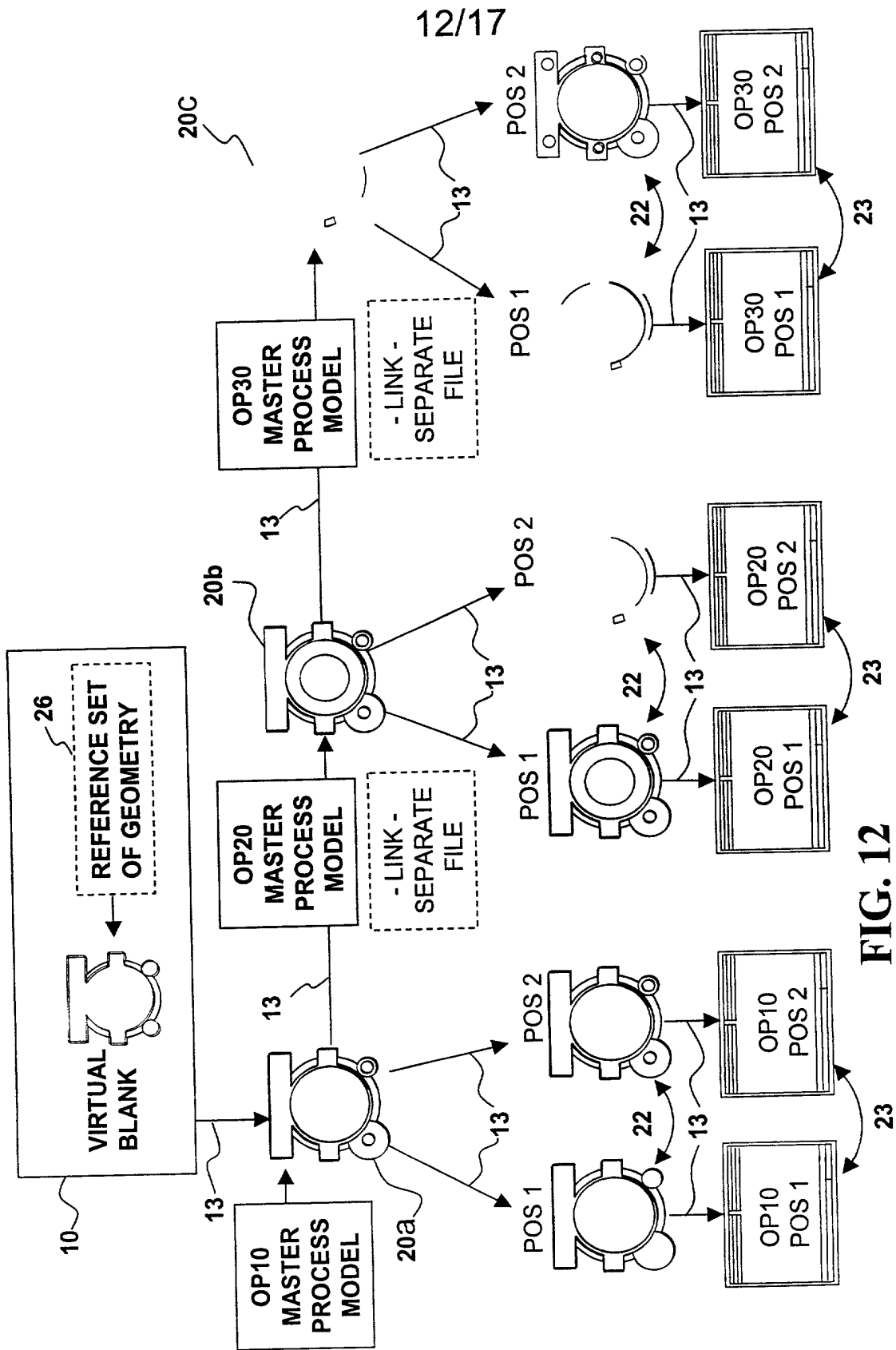


FIG. 12

13/17

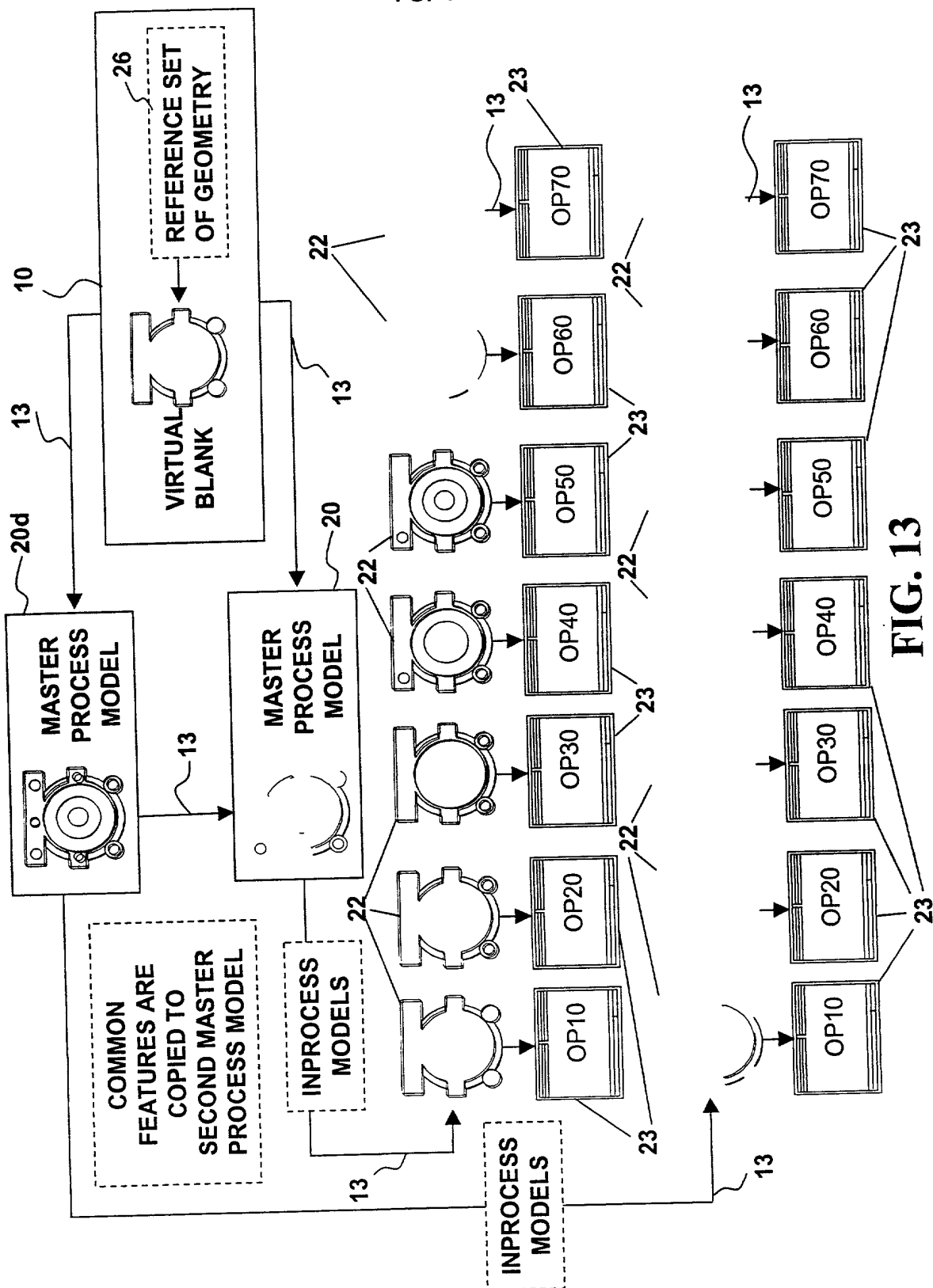


FIG. 13

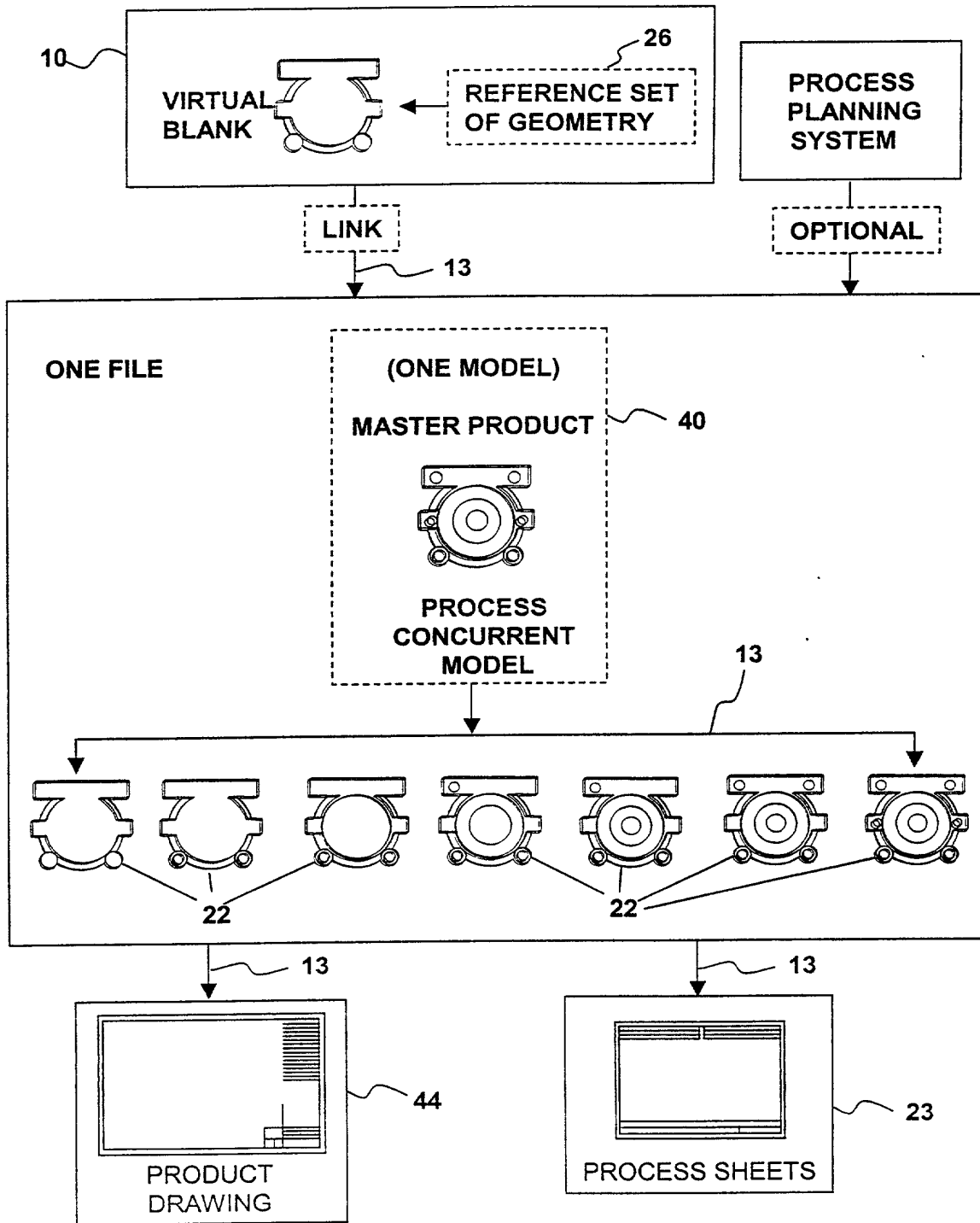


FIG. 14

15/17

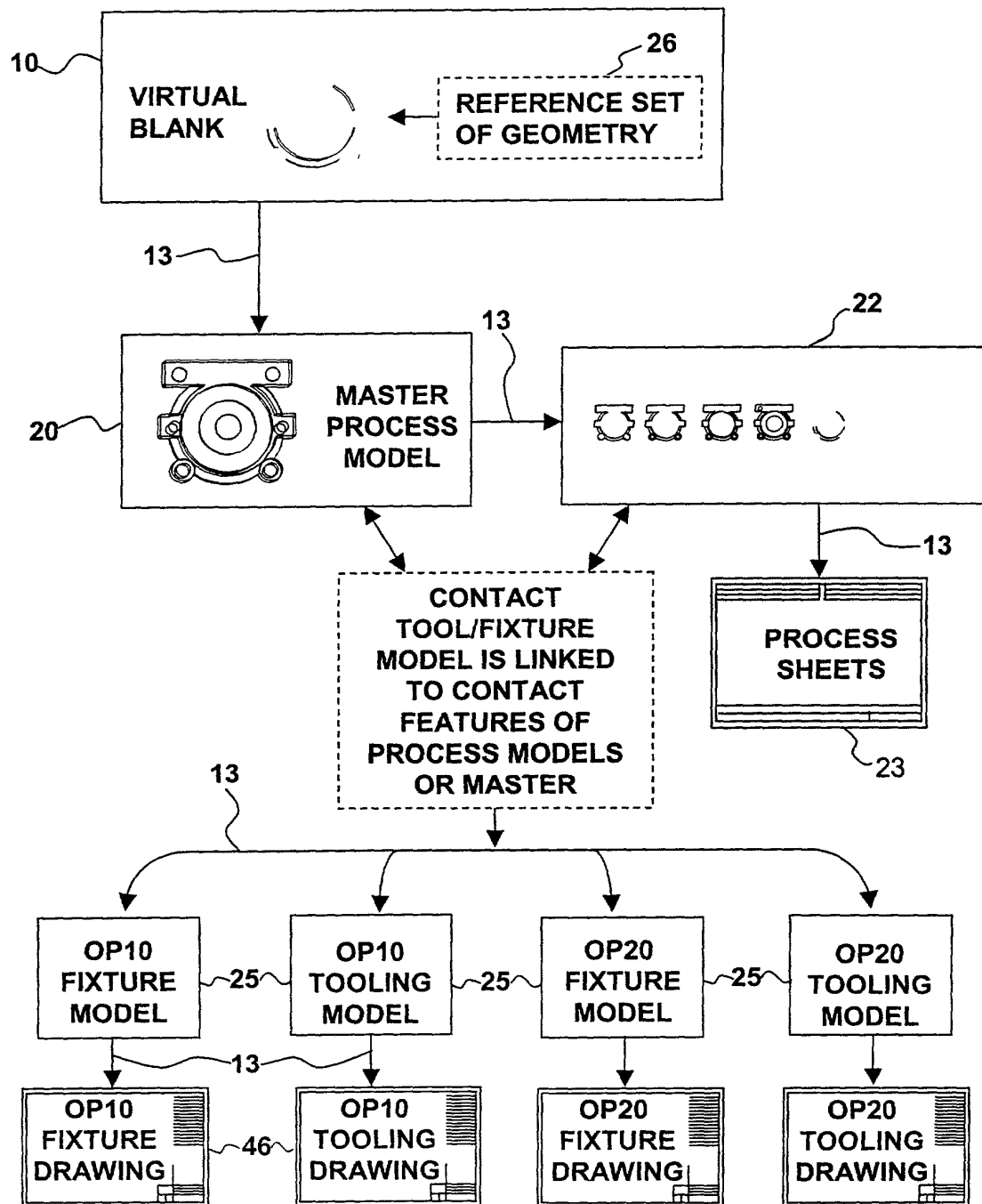


FIG. 15

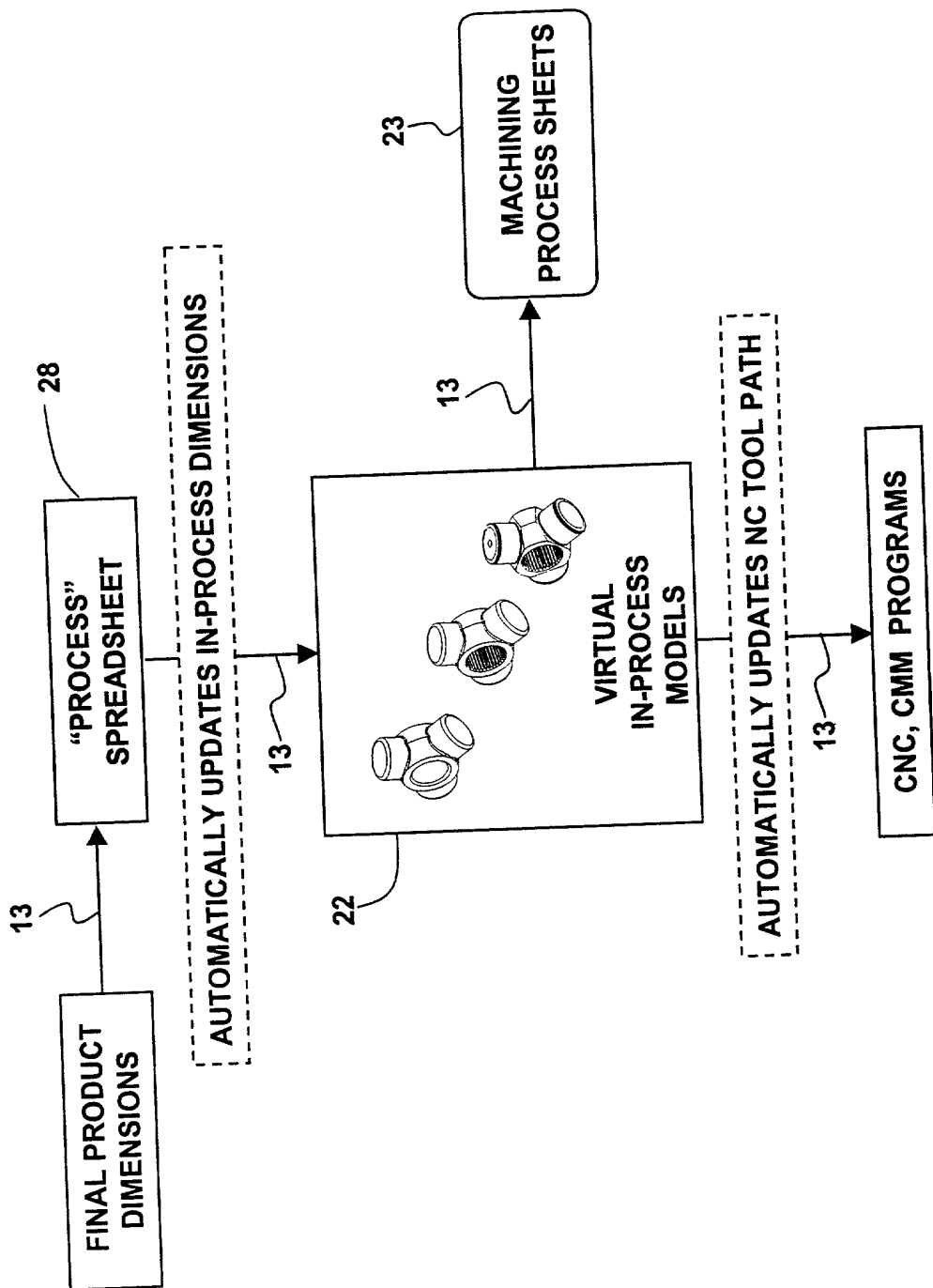


FIG. 16

FIG. 17

28

BLUE: FINAL PRODUCT DIMENSIONS		YELLOW HILITE: PROCESS RULE	
RED: CALCULATED IN-PROCESS DIMENSIONS BASED ON PROCESS RULES			
Operations	Part	Description	Parameters
Operation 11/13/74 Bore and Chamfer		Max Broached hole diameter after HT	max_broach_hole_dia 26.433
		Min Broached hole diameter after HT	min_broach_hole_dia 26.353
		Heat treat distortion	htd_broach 0.06
		Max minor diameter of Broached hole before HT	max_minor_dia 26.493
		Min minor diameter of Broached hole before HT	min_minor_dia 26.413
		Minimum recommended stock removal(broach)	min_stk_rem 0.203
		Maximum recommended stock removal (broach)	max_stk_rem 0.393
		Maximum Bored hole diameter	max_hole_dia 26.21
		Minimum Bored hole diameter	min_hole_dia 26.1
		Average Bored hole diameter	avg_hole_dia 26.155

AUTOMATICALLY UPDATES IN-PROCESS DIMENSIONS

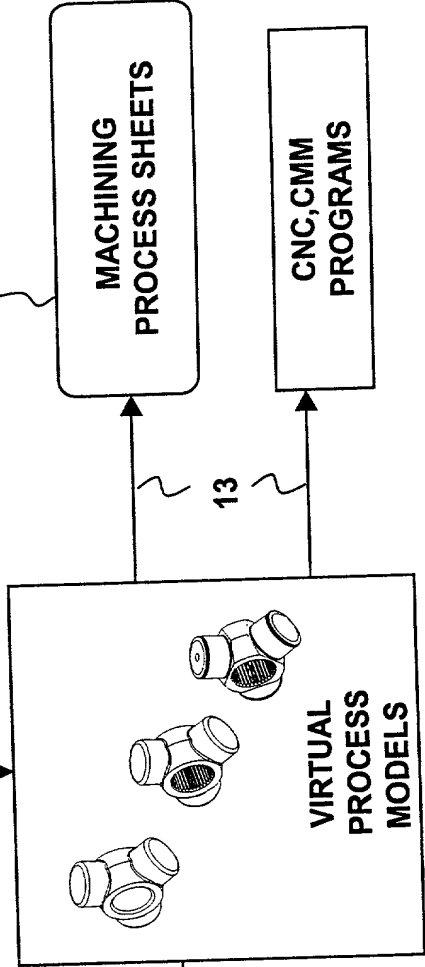


FIG. 17